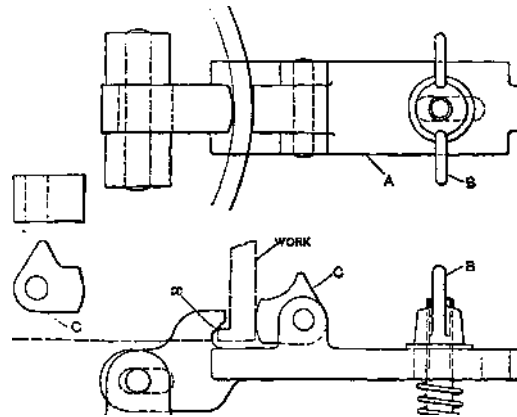
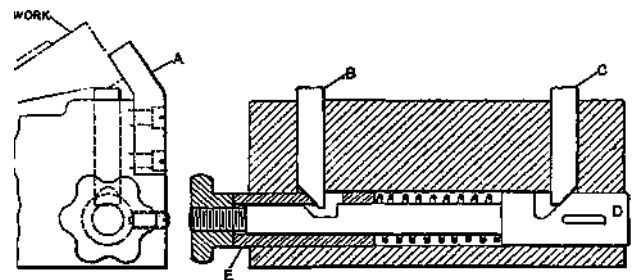


against the locating pins. The use of a roller instead of a screw prevents this. The roller *A* will turn until the work strikes both stop-pins. In the device illustrated, *B* and *C* are the fixed locating pins, and *D*, the clamp screw tapped into the bushing



Machinery

Fig. 16. Clamping Work by Holding it by Means of a Flange



Machinery

Fig. 17. A Heavy

Milling
Fixture
with
Equalizing
Clamping
Device

E operating the sliding plunger *G*. It is obvious that

the work can be prevented from binding by using two equalizing plungers to throw it against the locating pins instead of a roller.

Fig. 20 shows the locating mechanism for a milling fixture in which two pieces are located by two plungers each, all operated